Work Order ID Monday, March 17, 201			*115	181*						Page 1
Item ID: D3601 Revision ID:	-1	. ·	Accept	*N900040	1100	)*	Setup			S1*
Item Name: Radius	Block							Stop	*N:	S2*
<b>Start Date:</b> 3/17/14	~ .			Cust Item ID:						
Required Date: 3/17/14	4 <b>Req'd Qty:</b> 40.	<sup>00</sup> *40*		Customer:						
Reference: Approvals: Proce	ess Plan:	Date: 14 08 <b>19</b>	Tooling:	Date:			Run	Start	*N	R1*
QC:		Date:	SPC (Y/N):	Date:				Stop	*N	R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr							•		
D3601	Rev A	1								
*100*	SHEAR		0.00					v		/14/04/00
Shear Shear	Memo blanks	9.00" long +/- 0.030"Note: 1 blar	0.00 nk makes 8 pieces							,
		Ü								* ·
110			0.00	•				_		MLi
*110* HAAS 1	HAAS CNC VERTI	CAL MACHINING #1	0.00	·		48		<b>%</b>		MH 14/04/00
HAAS CNC vertical machine	e #1 1- Mill	as per Folio FA682 Rev: A	& Dwg D3601 Rev: <b>A</b>	· .						
120	QC2- Inspect parts of	off machine FAI/FAIB	0.00					~/		ми
*120*	. •					48		Ø		MH 14/04/09
QC Quality Control	Memo		0.00							· /

DQA:		. Date:			•								
					WORK ORDER NON-	-CC	ONFO	RMANCE / UF	PDATE				AEROSPACE
QA Closed:		Date:								Wo	ork Order up	odate only	
Work Orde	r:				DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS	
Part N NCR N					Rework Scrap Use-as-is Suspected Unapproved		I Thern	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
D4	1	<del></del>	ı	0									
Root	Data	Chan	٠	Desci	ription of work order update		nitial	Acti			Sign &		
Cause	Date	Step	Qty		or non-conformance	Cn	ief Eng	Descri	ption		Date	Verification	QC Inspector
Design Doc/Data	-											:	ĺ
Equip/Tooling													
Handling/Pre		:										<u>.</u>	
Material													
Operator													
Offset/Setup						İ						:	
Process													
Supplier						~							
Fraining													
Transport		ļ											
Unapproved													
L			1			FAI	ULT CAT	EGORY			L		
Landin	g Gear				General		,	- 1					
	Bending				Bend		Folio/P	rogram			Outside Dim	ensions	Pressure/Forced
	Centre No	ot Concei	ntric		BOM/Route		Grain				Over/Under	tolerance	Set-up
[	Cracks				Broken/Damage/Defect		Hardwa	re			Part Incorre	ci [	Temperature/Cure
	Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspecti	on Incomplete/Un	qualified		Part Lost/Mi	ssing	Weld
	Cuffs				Contamination		Instruct	ions Incomplete/U	nclear		Part Moved		Wrong Stock Pulled
	Crushing				Countersink		Misalig	ned/off center			Positioned V	Vrong	
	Heat Trea	ıt			Cut Too Short		Mislabe	led			Power Loss/	Surge	Other
Į	Inspection	n Strip in	Tube		Drawing		Misread	i					
ļ	Marks/Ch				Drill Holes		Off-set						
	Turning S	equence			Finish		Out of 0	Calibration					
	Wave/Tw	ist in Tul	oe		Fit/Function		Out of S	Sequence					

Work Orde Ionday, March					*	1151	181*						Page	2
Revision ID:	D3601-1 Radius Block			1	Accept	•	*N900	<b>0040</b>	100	<b>)*</b> s	etup Sta	·· 1 Vi	S1* S2*	
tart Date: Required Date: Reference:	3/17/14 3/17/14	<b>Start Qty:</b> 40.00 <b>Req'd Qty:</b> 40.00		*40* *40*			Cust Item Customer							
Approvals:		n:	Date:_ Date:_	f	Tooling SPC (Y.			Date:		R	eun Sta Sto	"I\]	R1* R2*	
equence ID/ Vork Center ID  30  *1 20*  QC  Quality Control	•	Operation Description QC8- Inspect parts - secon	nd check		Set U Run 0.00	Up/ Hours DAS 44 9-89	Tool ID		Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
*1 40 *1 40* Small Fab Gmall Fab		Small Fab  Memo 1-Tumble 2-Deburr any	rough edg	es after tumblinį	0.00 0.00					48	J.C.	NYYIT	·	· ·
*150 *150* HandFinish Hand Finishing		Chemical Conversion Coa	at per QSI0	05 4.1	0.00	DAS 27 9-69 MM K	2			48		-		- -

DQA:		Date	:	·	·			<b>.</b>				TRAGE
QA Closed:		Date			WORK ORDER NON-	-C(	ONFO	RMANCE / UI		Vork Order u	ndata anly	AEROSPACE
QA Closed.	<del></del>	Date	<u> </u>			_				vork Order u	puate only	i
Work Orde	er:				DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
	<u></u>		·		Rework	1		Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	lo.				Scrap	1		Machining	Small Fab	-  Pro	od. Eng. Coor.	Quality
					Use-as-is			noforming	Finishing	-1	re/Packaging	Other
NCR N	lo				Suspected Unapproved			Large Fab	Composite		Supplier	
Root				Desci	ription of work order update		Initial	Acti	ion	Sign &		
Cause	Dat	e Step	Qty	<u> </u>	or non-conformance	Ch	nief Eng	Descr	iption	Date	Verification	QC Inspector
Design											1	
Doc/Data												
Equip/Tooling												
Handling/Pre												
Material		:										
Operator							-					
Offset/Setup				ļ		ŀ						
Process												
Supplier												
Training												
Transport				1		Ì						
Unapproved						<u> </u>						
		V-1-				FA	ULT CA	regory				
Landi	ng Gear			_	General	_	-		-	_		_
	Bendi	-			Bend		•	'rogram	L	Outside Dim	nensions	Pressure/Forced
		Not Conce	entric		BOM/Route	_	Grain			Over/Under	tolerance	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	ire	L	Part Incorre	cí	Temperature/Cure
	Crimp	/Kink/Rippl	e/Wave	_	Burrs	<u> </u>	Inspect	ion Incomplete/Un	qualified	Part Lost/M	_	Weld
	Cuffs				Contamination		4	ions Incomplete/U	Inclear	Part Moved		Wrong Stock Pulled
	Crush	_			Countersink		-1 -	ned/off center	L	Positioned \		<u>,                                    </u>
	Heat 1			L	Cut Too Short		Mislabe		L	Power Loss,	/Surge	Other
		tion Strip i	n Tube		Drawing		Misread					
	_	/Chatter		<u> </u>	Drill Holes		Off-set				· · · · · · · · · · · · · · · · · · ·	
,		g Sequenc			Finish		-1	Calibration				
	Wave,	/Twist in Tu	be		Fit/Function	1	Out of	Sequence				

Work Order ID 115181 Monday, March 17, 2014 2:49:53 PM		*11 <i>5</i>	181*				Page 3
Item ID: D3601-1 Revision ID: Item Name: Radius Block Start Date: 3/17/14 Start Qty: 40 Required Date: 3/17/14 Req'd Qty: 40	.00 <b>*4</b> 0 <b>*</b>	Accept	*N90002  Cust Item ID: Customer:	4 <b>010</b>	<b>n*</b> s	Setup Star Stop	14'21
Approvals: Process Plan:QC:		Tooling: SPC (Y/N):	Date: Date:		R	tun Star Stop	"IVH I"
*170*		Set Up/ Run Hours 0.00 0.00	Tool ID To	ool# Plan Code	Accept Qty  48x	9-8	
Packaging Packaging  180 QC21- Final Inspector  *1 QC  Memory Quality Control	ction - Work Order Release	0.00				9-89	R1404-14

S 1

DQA:		Date:						_					,	TRAGE
					WORK ORDER NON-	-C(	ONFO	RMANCE / UI	PDATE			-		AEROSPACE
QA Closed:		Date:								W	ork Order up	odate only	$\Box$	
Work Orde	er:				DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
					Rework	ı		Skid-tube	Crosstube		]	Water Jet	٦	Engineering
Part N	lo.				Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	┪	Quality
					Use-as-is			noforming	Finishing		1	re/Packaging	┪	Other
NCR N	lo			_	Suspected Unapproved			Large Fab	Composite			Supplier		
Root				Descr	ription of work order update	П	Initial	Act	ion		Sign &		П	
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption		Date	Verification	١	QC Inspector
Design														
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material						Ì							ĺ	
Operator														
Offset/Setup													1	
Process														
Supplier	_													
Training														
Transport														
Unapproved			1											
						FA	ULT CAT	regory					_	
Landir	ng Gear				General	_	3			_	1	-	_	
	Bendin	_			Bend	<u> </u>	4	rogram		<u> </u>	Outside Dim	- F		Pressure/Forced
-	_	Not Conce	ntric	<u> </u>	BOM/Route	$\vdash$	Grain			L	Over/Under		$\dashv$	Set-up
-	Cracks				Broken/Damage/Defect		Hardwa			_	Part Incorre	<b>-</b>	$\neg$	Temperature/Cure
		Kink/Ripple	e/Wave	-	Burrs	⊢	<b>-</b> 1	ion Incomplete/Un	•	<u> </u>	Part Lost/Mi	- L		Weld
	Cuffs			_	Contamination	<u> </u>	4	ions Incomplete/L	Inclear	$\vdash$	Part Moved			Wrong Stock Pulled
	Crushir	-		_	Countersink	<u> </u>	-	ned/off center		-	Positioned V	· ·	_	0.1
	Heat Ti		. Tl	<u> </u>	Cut Too Short	L	Mislabe				Power Loss/	Surge [		Other
		ion Strip ir	ıube	_	Drawing	$\vdash$	Misrea						—	
		Chatter		<u> </u>	Drill Holes	<u> </u>	Off-set						—	
		Sequence		<u> </u>	Finish	$\vdash$	-	Calibration						
	wave/	Twist in Tu	pe		Fit/Function		JOut of S	Sequence						

**Picklist Print** 

Monday, March 17, 2014 2:49:53 PM

Work Order ID: 115181

\*115181\*

Parent Item:

D3601-1

\*D3601-1\*

Parent Item Name: Radius Block

**Start Date: 3/17/14** 

Required Date: 3/17/14

**Start Oty: 40.00** 

\*\*

Required Qty: 40.00

**Comments:** 

IPP Rev:A New Issue 07-03-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B00750X00.1		Purchased	No			f	52.5920		2.664			

\*M6061T6B00750X00 125\*

6061-T6 Bar .750 x .125

Location Loc Qty Loc Code MAT049 52.592 M127818 52.592

5/25' /14/04/06

DQA:	<u> </u>	Date	:									TQAC
OA Clasadi		Data			WORK ORDER NON-	-C(	ONFO	RMANCE / UPDATE	14/	- ulo Oud - u		AEROSPACE
QA Closed:	-	Date	•						W	ork Order up	date only	
Work Orde	er:				DISPOSITION			AGAI	NST DE	PARTMENT	/PROCESS	
					Rework	1		Skid-tube Crosst	ube	1	Water Jet	Engineering
Part N	lo.				Scrap			Machining Small		Pro	d. Eng. Coor.	Quality
					Use-as-is		Thern	noforming Finis	hing	Rec/Sto	re/Packaging	Other
NCR N	lo				Suspected Unapproved			Large Fab Compo	site	]	Supplier	
Root			1	Desc	ription of work order update		Initial	Action		Sign &		
Cause	Da	te Step	Qty		or non-conformance	ı	nief Eng			Date	Verification	QC Inspector
Design			1	<u> </u>		-		200,,,			TOTHIOGE IOI	QO IIISPECCO.
Doc/Data												
Equip/Tooling												
Handling/Pre												
Material												ĺ
Operator												
Offset/Setup												
Process										· .		
Supplier	_					l						
Training												j
Transport												
Unapproved				<u> </u>								
=						FA	ULT CA	TEGORY				
Landi	ng Gear				General		1 .	•		7	r-	_
	Bend	-			Bend	<u> </u>	4	Program	-	Outside Dim	· -	Pressure/Forced
		e Not Conc	entric	-	BOM/Route	<u> </u>	Grain		ļ	Over/Under		Set-up
	Crack		- 64.	<u> </u>	Broken/Damage/Defect	$\vdash$	Hardwa		<u> </u>	Part Incorred	<b>-</b>	Temperature/Cure
		o/Kink/Ripp	e/Wave	<u> </u>	Burrs	$\vdash$	1 ·	ion Incomplete/Unqualified	L	Part Lost/Mi	ssing	Weld
	Cuffs			<u> </u>	Contamination	$\vdash$	4	tions Incomplete/Unclear	<u> </u>	Part Moved	. <i>.</i>	Wrong Stock Pulled
	Crush	_		-	Countersink Cut Too Short	$\vdash$	1	gned/off center	<u> </u>	Positioned V		Othor
	_	Treat ction Strip i	n Tuba	-	-	$\vdash$	Mislabe		L	Power Loss/	ourge	Other
		s/Chatter	ii iube		Drawing Drill Holes	$\vdash$	Misrea Off-set				T	
		ng Sequenc	۵	$\vdash$	Finish	$\vdash$	4	Calibration		-		
		rig sequence e/Twist in Tu		-	Fit/Function		4	Sequence				
	1000	,, , <del>, , , , , , , , , , , , , , , , ,</del>			p rg r uniculon	1	Jour of .	ocquence .				

DART AEROSPACE LTD	Work Order:	115181
Description: Radius Block	Part Number:	D3601-1
Inspection Dwg: D3601 Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/-0.030	e746			NH ~04	Calipen
0.375	+/-0.010	-374			ł	
0.375	+/-0.010	.365			12 802	
Ø0.257	+0.006/-0.001	-257			TO TO	
0.357	+/-0.010	- 376			V	
R0.38	+/-0.030	·38			Rad Sand	
0.80	+/-0.030	. 805	J		MH-04	1
O <sub>•</sub> 0.3 x 45°	+/-0.010 x 0.5°	.035x4S	1		1	

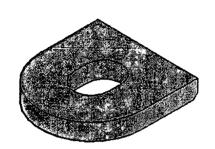
Measured by: YH	Audited by:	F.K	Preliminary Approval:	
Date: ۱٩/٥٩/৩٩	Date:	14/04/09	Date:	·

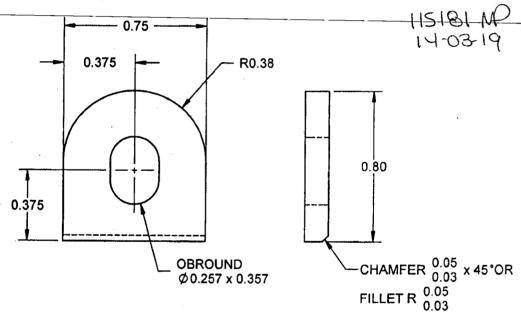
Rev	Date	Change	Revised by	Approved
Α	07.05.08	New Issue	KJ/JLM	
В	11.08.22	Dimensions updated	KJ 💖	1 12
				, -

	्राच्या विकास सम्बद्धिः विकास भागायाः क्रम्यस्थानाः क्रमाताः क्रमाताः व					
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	<i>y</i>					
						V
<u>.</u>						4



DESIGN CB		DRAWN BY	DART AEROSPACE I HAWKESBURY, ONTARIO, CAN	
CHEC	KED 6	APPROVED	DRAWING NO.	REV. A
	<u>_P</u>		D3601	SHEET 1 OF 1
DATE			TITLE	SCALE
07.02.13			RADIUS BLOCK	2:1
REV DATE			DESCRIPTION	
Α		07.02.13	NEW ISSUE	





## D3601-1 RADIUS BLOCK

NOTES:

1) MATERIAL: ALUMINUM 5052-H32 SHEET, 0.125 THICK PER QQ-A-250/8 OR AMS 4016
(REF DART SPEC M5052H32S.125) OR
ALUMINUM 6061-T6 SHEET, 0.125 THICK PER QQ-A-250/11 OR AMS 4025/4027
(REF DART SPEC M6061T6S.125)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) IDENTIFY WITH DART P/N "D3601-1" USING FINE POINT PERMANENT INK MARKER

4) IDENTIFY WITH DART P/N "D3601-1" USING FINE POINT PERMANENT INK MARKER
5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
6) BREAK ALL SHARP EDGES 0.005 TO 0.050 MAX

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